

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005966**Date Inspected:** 23-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai ,China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Paint Shop

Segment 5AW

This QA Inspector performed a preliminary random visual inspection after the grit blast of the internal components of the bottom and side plates. Areas of visual indications that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel have been made aware of these defects but were not were present at the time of inspection.

South of Bay 14

Segment 4BE

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of the side plate to corner assembly splice welds previously rejected by ZPMC QC personnel. The welder is identified as #067183. The weld designation is SEG20A-032. ZPMC QC is identified as Mr. Li Yan Hua. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-Repair.

Shielded Metal Arc Welding (SMAW) in the 1G position of the transverse deck panel stiffeners at the crossbeam. The welder is identified as #200432. The weld designation is SEG24-X8E. ZPMC QC is identified as Mr. Li Yan

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Hua. The welding variables recorded by QC appear to comply with the applicable WPS.

Shielded Metal Arc Welding (SMAW) in the 4G position of the deck plate to corner assembly splice welds previously. The welder is identified as #037996. The weld designation is SEG20*-026. ZPMC QC is identified as Mr. Li Yan Hua. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-Repair.

Segment Repair Yard (North of the paint shop)

Segment 1BE

Shielded Metal Arc Welding (SMAW) in the 2G position of the deck panel diaphragm to floor beam flange excessive gap weld repair. The welder is identified as #055564. The weld designation is SSD45-PP10.5-003. ZPMC QC is identified as Mr. Li Yan Hua. The welding variables recorded by QC appear to comply with the applicable WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, (15000422372), who represents the Office of Structural Materials for your project.

| | | |
|----------------------|------------------|-----------------------------|
| Inspected By: | Patterson,Rodney | Quality Assurance Inspector |
| Reviewed By: | Carreon,Albert | QA Reviewer |
